

Work Order ID 95118

January-02-13 1:55:25 PM

95118

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Item ID: D2274

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Radius Block

Stop ***NS2***

Start Date: 1/02/13 Start Qty: 280.00

280

Cust Item ID:

Required Date: 1/25/13 Req'd Qty: 280.00

280

Customer:

Reference:

Approvals:

Process Plan:

RL

Date/13-01-1

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	SHEAR								
Shear	Memo	0.00							
Shear	blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2274								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120	Memo	0.00							
QC									
Quality Control									

*FK 13/01/10 286 Ø**P0 13/01/13 286 Ø**P0 13/01/13 286 Ø*

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS											
Part No. _____	Work Order:	Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>									
NCR No. _____	Part No. _____	NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>									
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>									
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>										
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	<input type="checkbox"/>			Bend	<input type="checkbox"/>			Grain	<input type="checkbox"/>			Ovalized	<input type="checkbox"/>			Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/>			BOM/Route	<input type="checkbox"/>			Hardware	<input type="checkbox"/>			Over/Under tolerance	<input type="checkbox"/>			Temperature/Cure
Cracks	<input type="checkbox"/>			Broken/Damaged	<input type="checkbox"/>			Inspection Incomplete	<input type="checkbox"/>			Part Incorrect	<input type="checkbox"/>			Weld
Crushed/Crimped	<input type="checkbox"/>			Burrs	<input type="checkbox"/>			Instructions Incomplete/Unclear	<input type="checkbox"/>			Part Lost/Missing	<input type="checkbox"/>			Wrong Stock Pulled
Cuffs	<input type="checkbox"/>			Contamination	<input type="checkbox"/>			Maintenance	<input type="checkbox"/>			Part Moved	<input type="checkbox"/>			
Heat Treat	<input type="checkbox"/>			Countersink	<input type="checkbox"/>			Mislabeled	<input type="checkbox"/>			Positioned Wrong	<input type="checkbox"/>			
Inspection Strip in Tube	<input type="checkbox"/>			Cut Too Short	<input type="checkbox"/>			Misread	<input type="checkbox"/>			Power Loss/Surge	<input type="checkbox"/>			
Ripples in Bend	<input type="checkbox"/>			Drill Holes	<input type="checkbox"/>			Offset	<input type="checkbox"/>				<input type="checkbox"/>			
Torque Waves in Extrusion	<input type="checkbox"/>			Drawing	<input type="checkbox"/>			Out of Calibration	<input type="checkbox"/>				<input type="checkbox"/>			
Turning Sequence	<input type="checkbox"/>			Finish	<input type="checkbox"/>			Out of Sequence	<input type="checkbox"/>				<input type="checkbox"/>			
Wave/Twist in Tube	<input type="checkbox"/>			Folio	<input type="checkbox"/>			Outside Dimensions	<input type="checkbox"/>				<input type="checkbox"/>			

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Item ID: D2274 Accept *N900040100* Setup Start *NS1*
Revision ID:
Item Name: Radius Block Stop *NS2*
Start Date: 1/02/13 Start Qty: 280.00 *280* Cust Item ID:
Required Date: 1/25/13 Req'd Qty: 280.00 *280* Customer:
Reference:
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	13/01/14		286	0		DAS 08 283
140 *140* Small Fab Small Fab Small Fab	Small Fab Memo TumbleDeburr any rough edges after tumbling	0.00 0.00			(286)	286	13-1-16		
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				286	13-1-24		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order ID 95118

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Item ID: D2274

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Radius Block

Stop

NS2

Start Date: 1/02/13 Start Qty: 280.00

280

Cust Item ID:

Required Date: 1/25/13 Req'd Qty: 280.00

280

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC	QC7-Inspect Chemical Conversion Coat	0.00	<i>SM</i>			<i>280</i>			
Quality Control	Memo	0.00	<i>13-1-28</i>						
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>008</i>	0.00							<i>13/1/28 (206)</i>
	Memo	0.00							
180 *180* QC	QC21- Final Inspection - Work Order Release	0.00							<i>13/1/28 (206)</i>
Quality Control	Memo	0.00							

*13-01-28**13/1/28 (206)*

NCR: Yes / No

DQA: Date: ;

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Picklist Print

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Page 1

Work Order ID: 95118

Parent Item: D2274

Parent Item Name: Radius Block

Start Date: 1/02/13

Required Date: 1/25/13

Start Qty: 280.00

Required Qty: 280.00

Comments: IPP H00.05.18 Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.125 6061-T6 Bar .750 x .125		Purchased	No			100	f	50.2895	0.0916	26.997908			

Location	Loc Qty	Loc Code
MAT049	50.28945	
122753	8.5	
123279	41.78945	

27.821 F.K. 13/01/10

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
Work Order Update <input type="checkbox"/>								Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio						
				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge						
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled						
				<input type="checkbox"/> Other						

DART AEROSPACE LTD	Work Order:	95118
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	PO	Audited by:	h.a	DAS	08	Prototype Approval:	N/A
Date:	13/01/13	Date:	13/01/14		88	Date:	N/A

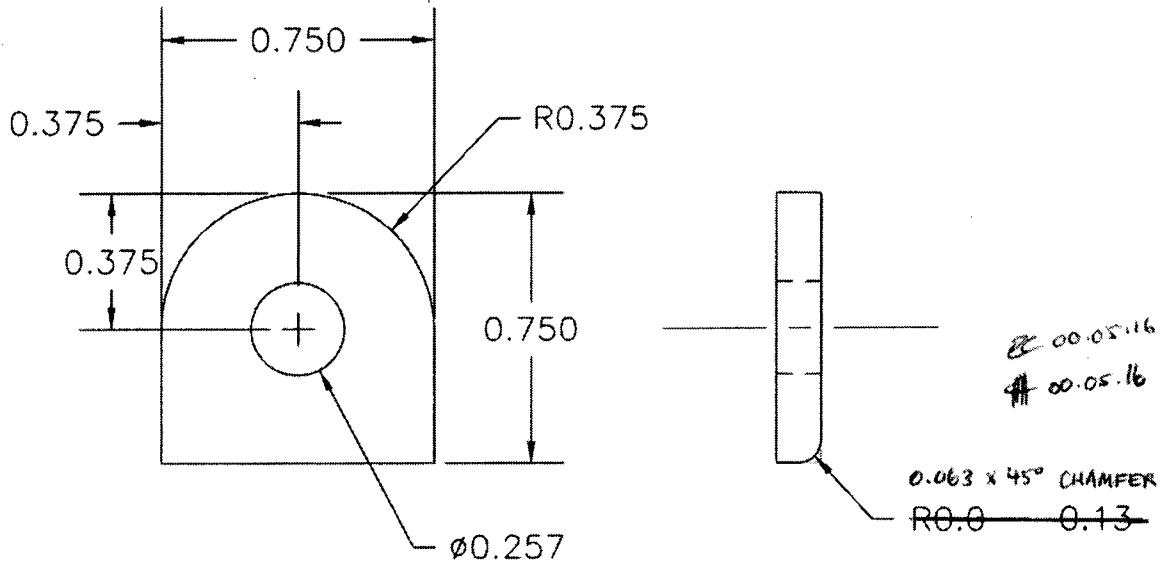
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TT

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED NO	APPROVED JS	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED

98/08/18 KE

95118
PL/13-01-7

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
 OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED